

84067

Wednesday, May 02, 2012 1:03:33 PM

N900040100

Setup Start *NS1*

Stop *NS2*

10

10

Reference:

Date: 1205-2

Date:

Run Start *NR1*

Date:

Date:

Stop *NR2*

100		0.00		
100				
Waterjet				
FLOW CNC Waterjet				
304 .063				
	Memo	0.00		
	Cut as per dwg			
	Prog rev: <u>A</u>			
	dwg rev: <u>A</u>			
110	QC2- Inspect parts off machine FAI/FAIB	0.00		
110				
QC				
Quality Control	Memo	0.00		
120	QC8- Inspect parts - second check	0.00		
120				
QC				
Quality Control	Memo	0.00		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84067***84067***

Page 2

Wednesday, May 02, 2012 1:03:33 PM

Item ID: D4070-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp

Start Date: 5/2/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Form as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

150

0.00

150

Small Fab

Memo

0.00

Small Fab

Assemble rubber cushion as per dwg



12/02/10



9

/

FF
12-02-02

W/O: 84067		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4070-041 PAR #: _____ Fault Category: Small FAB NCR: Yes No DQA: [Signature] Date: 12/08/13
 Resolution: _____ Disposition: Scrap QA: N/C Closed: [Signature] Date: 12/8/14

NCR: 12-11673		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/67/19	130	1 part moved while forming out of tolerances P.C process	 057047 12/19/20	Scrap & destroy Q7 x1	12/02/19 [Signature] 12/67/19 [Signature]	 057047 12/19/20	 12/19/20	

NOTE: Date & initial all entries

Work Order ID 84067

Wednesday, May 02, 2012 1:03:33 PM

84067

Page 3

Item ID: D4070-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp

Start Date: 5/2/2012 Start Qty: 10.00 ***10***

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 10.00 ***10***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 12/08/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 02, 2012 1:03:37 PM

Page 1

Work Order ID: 84067

84067

Parent Item: D4070-041

D4070-041

Parent Item Name: Clamp

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A 10.02.16 new issue EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2182B		Manufactured	No				f	168.9332					
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D2182B

Rubber Cushion

**

1.578947

9

FF/12-08-02

Location	Loc Qty	Loc Code
ST410	386201	168.93317
63413	1.6	
66063	41.61817	
73932	125.715	

16.2

Cut qty 1 at 1.80" long

M304S16GA

Purchased

No

100

sf

94.3720

0.019

0.2

SF

**

M304S16GA

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	94.372	
120866	14.246	
120877	80.126	

121626

121626

Jm
12-6-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

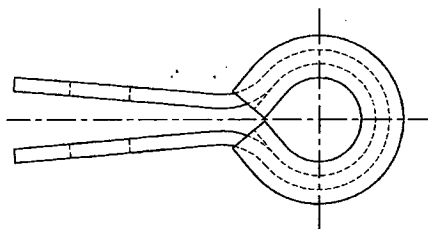
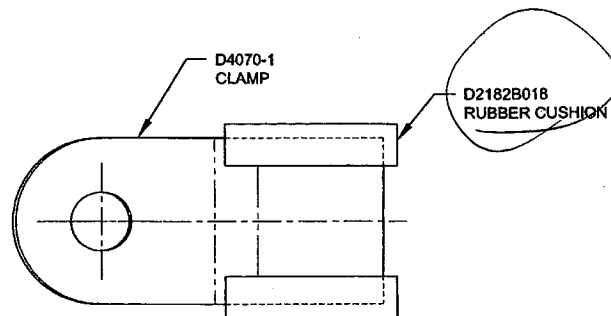
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4070-041 CLAMP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 841067

RL12-052

RELEASED
2010-02-16
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4070-041" USING REMOVABLE TAG
- 7) WEIGHT: 0.05 lbs

QTY	PART NUMBER	DESCRIPTION
X	D4070-041	CLAMP
1	D4070-1	CLAMP
1	D2182B018	RUBBER CUSHION

REV.	DESCRIPTION	CP	DATE
A	NEW ISSUE	BY	10.02.12
DESIGN			
DRAWN			
CHECKED			
MR-G. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4070** REV. A
SHEET 1 OF 3

TITLE **CLAMP** SCALE **NTS**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

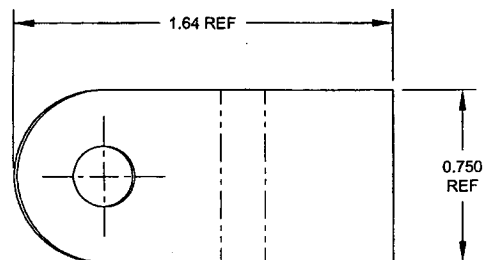
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

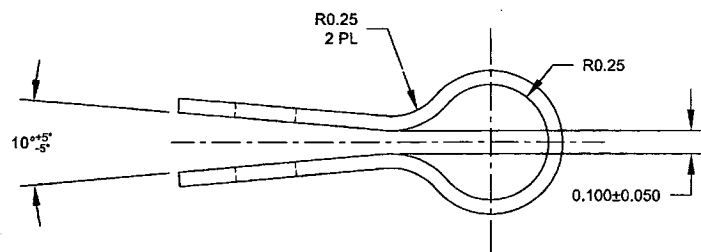
D

D



C

C



B

B

D4070-1 CLAMP
(MAKE FROM D4070-1F)

84067

RELEASED
2010-02-16
MD

A

A

NOTES:

- 1) MATERIAL: MAKE FROM D4070-1F
- 2) FINISH: POWDER COAT "BLACK SANDEK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs

DESIGN	91	DART AEROSPACE LTD	
DRAWN	91	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	91	D4070	SHEET 2 OF 3
APPROVED	91	TITLE	SCALE
DE APPR.	91	CLAMP	NTS
DATE	10.02.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

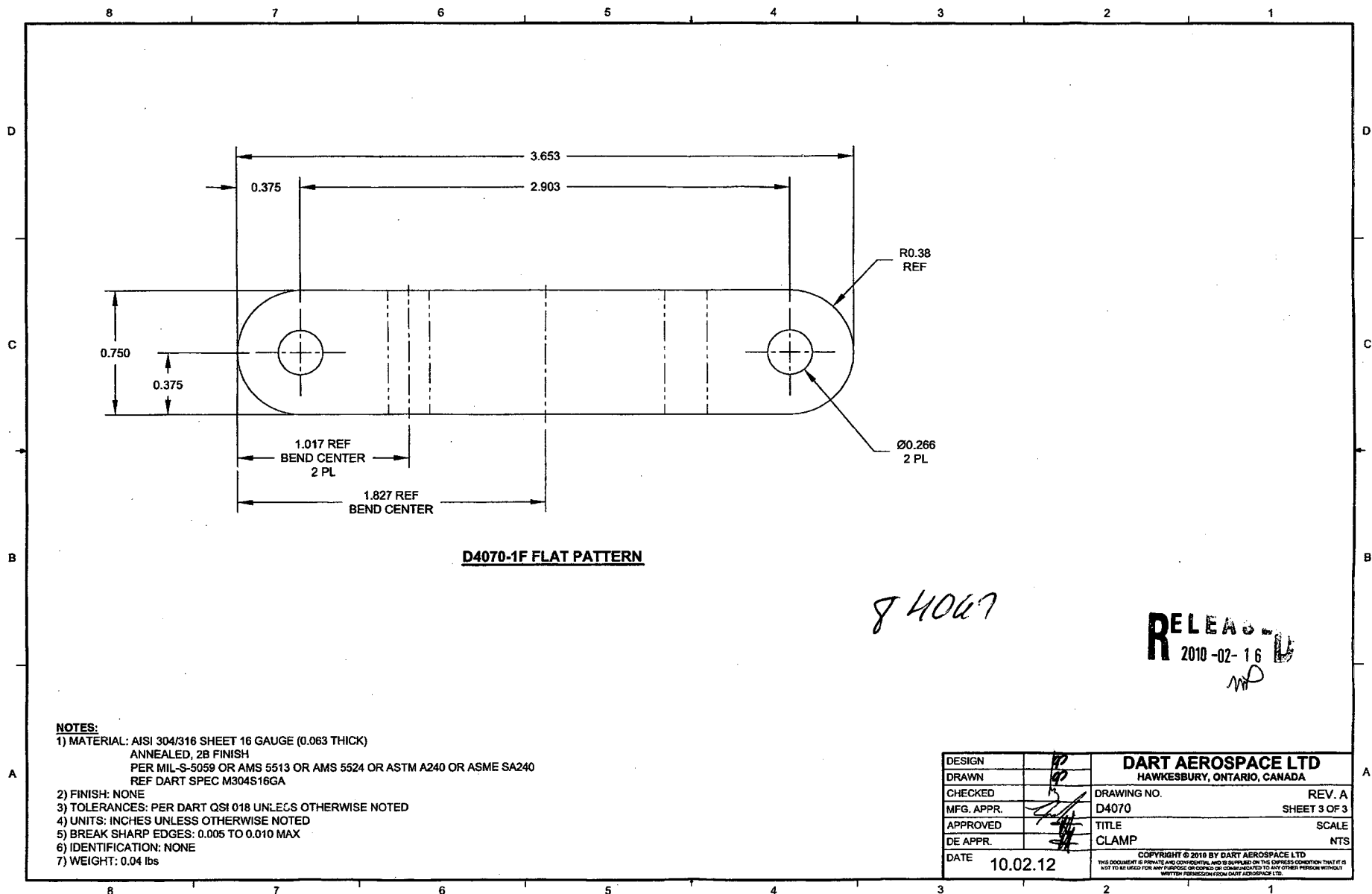
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